

(19)



Europäisches Patentamt  
European Patent Office  
Office européen des brevets



(11) Publication number:

**0 500 941 A1**

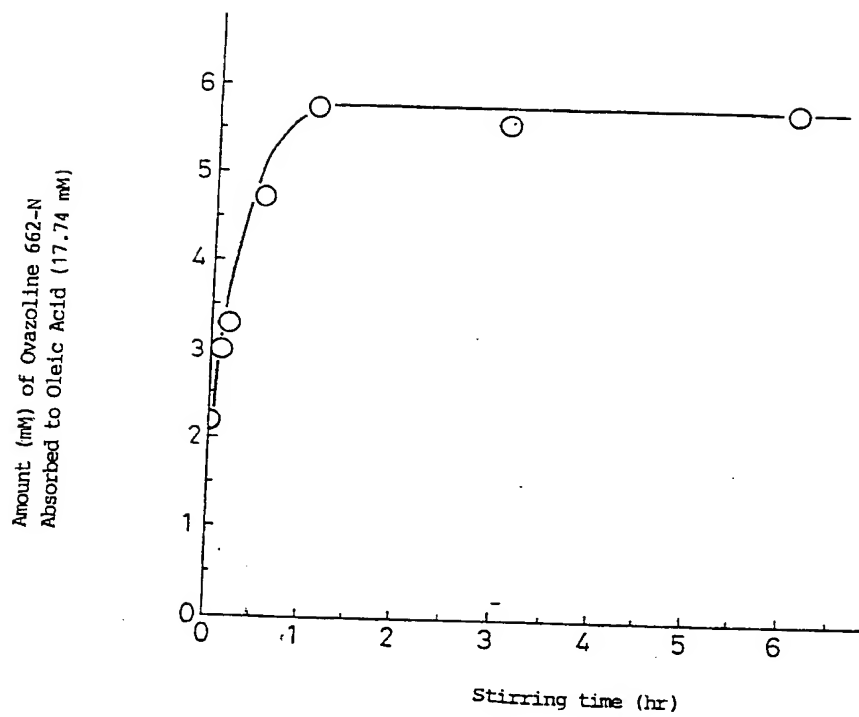
(12)

**EUROPEAN PATENT APPLICATION**  
published in accordance with Art.  
158(3) EPC

(21) Application number: **91911083.3**(22) Date of filing: **15.06.91**(86) International application number:  
**PCT/JP91/00807**(87) International publication number:  
**WO 91/19562 (26.12.91 91/29)**(51) Int. Cl.<sup>5</sup>: **B01F 17/00, B01F 17/16,  
B01F 17/22, B01F 17/26,  
B01F 17/28, B01J 13/00,  
A61K 7/00, A61K 7/06**(30) Priority: **15.06.90 JP 157257/90**  
**11.06.91 JP 166367/91**(43) Date of publication of application:  
**02.09.92 Bulletin 92/36**(84) Designated Contracting States:  
**AT BE CH DE DK ES FR GB IT LI LU NL SE**(71) Applicant: **SHISEIDO COMPANY LIMITED**  
**5-5 Ginza 7-chome**  
**Chuo-ku Tokyo 104(JP)**(72) Inventor: **NAKAMA, Yasunari, Shiseido Lab.**  
**1050, Nippa-cho Kohoku-ku**  
**Yokohama-shi Kanagawa 223(JP)**  
Inventor: **YAMAGUCHI, Michihiro,**  
**Shiseido-Lab.**  
**1050, Nippa-cho Kohoku-ku**  
**Yokohama-shi Kanagawa 223 3(JP)**  
Inventor: **MIYAZAWA, Kiyoshi, Shiseido Lab.**  
**1050, Nippa-cho Kohoku-ku**  
**Yokohama-shi Kanagawa 223(JP)**  
Inventor: **OHMURA, Takayuki, Shiseido Lab.**  
**1050, Nippa-cho Kohoku-ku**  
**Yokohama-shi Kanagawa 223(JP)**(74) Representative: **Hale, Stephen Geoffrey**  
**J.Y. & G.W. Johnson Furnival House 14/18**  
**High Holborn**  
**London WC1V 6DE(GB)****EP 0 500 941 A1**(54) **NOVEL COMPOSITE AND EMULSION COMPOSITION.**

(57) A novel composite comprising an ampholytic surfactant and/or a semipolar surfactant, a higher fatty acid and, if necessary, a clay mineral; and an emulsion composition containing the same.

Fig. 1



## TECHNICAL FIELD

The present invention relates to a novel complex and an emulsified composition, and more specifically, to a novel complex obtained by mixing an ampholytic surfactant and/or a semi-polar surfactant (hereinafter referred to as "ampholytic surfactant, etc.") and a higher fatty acid, as well as an emulsified composition comprising the novel complex and being easily prepared, having an emulsification type selectable from an O/W type to a W/O type, and exhibiting little irritation of the skin.

## BACKGROUND ART

In general, when preparing an emulsified product, a nonionic surfactant or an ionic surfactant is used as an emulsifier.

Nevertheless, because the oily substance to be emulsified exhibits various polarities, to obtain a stable emulsified substance, a measure of first obtaining the degree of polarity (the "required HLB") of the oily substance and then selecting a surfactant in conformity with that degree of polarity before using the agent, is taken. As the emulsifier, in many cases a hydrophilic emulsifier with a high HLB value and a lipophilic emulsifier with a low HLB value are combined with one another.

As a lipophilic emulsifier with a high HLB value, e.g., anionic surfactants such as fatty acid soap and alkylsulfuric ester salt; cationic surfactants such as distearyldimethylammonium chloride and stearyltrimethylammonium chloride; and nonionic surfactants having a long polyoxyethylene chain length, e.g., polyoxyethylene alkylether, polyoxyethylene fatty ester and polyoxyethylene sorbitan fatty ester, are used.

Further, as a lipophilic emulsifier with a low HLB value, e.g., a nonionic surfactant with a short polyoxyethylene chain, sorbitan fatty esters and glycerine fatty esters are used.

The required HLB value of an oily substance to be emulsified is obtained by using a nonionic surfactant having an already known HLB value. Very complex means are required for obtaining the required value, e.g., the ratio of the amounts of a surfactant with a high HLB and a surfactant with a low HLB is varied. Further, an emulsifier is selected on the basis of the required HLB thus-obtained, and an emulsified product is prepared using this emulsifier. Nevertheless, a stable emulsified product is seldom obtained in practice, and thus experiments must be repeated on a trial and error basis.

To cope with the above problem, it is disclosed that an emulsifier containing an alkanolamine of oleic acid and an anionic surfactant can emulsify a comparatively wide range of HLB (refer to Japanese Unexamined Patent Publication No. 61-114724), but an emulsified product prepared by using the above surfactant as an emulsifier has a drawback in that it has a high skin irritation effect.

Conversely, an ampholytic surfactant is known to exhibit a low skin irritation, and a large number of emulsified products consisting essentially of an ampholytic surfactant, e.g., a low skin irritation detergent composition, or a shampoo composition with a low irritation of the eyes, etc., have been disclosed (refer to the official gazettes of Japanese Unexamined Patent Publication No. 57-90099 and U.S. Patent No. 3,950,417).

The ampholytic surfactant disclosed in these official gazettes, however, do not exhibit a strong emulsification of an oily substance with a wide range of required HLB, and furthermore, an emulsion type of O/W or W/O is difficult to control and a stable emulsified product can not be formed.

Accordingly, there has not been obtained an emulsifier displaying a strong emulsification of even an oily substance with a wide range of required HLB, capable of easily controlling the emulsification type, and capable of producing a stable emulsified product having a low skin irritation.

## DISCLOSURE OF THE INVENTION

An object of the present invention is to provide a novel complex displaying an excellent emulsification of even an oily substance with a wide range of HLB, without the above-mentioned problems of the prior arts, and able to easily control the emulsification type, and able to be used also as an emulsifier able to form a stable emulsified product having a low skin irritation.

Another object of the present invention is to provide an emulsified composition able to be easily prepared even when containing an oily substance with a wide range of required HLB, and having an excellent stability and a low skin irritation.

The other objects and advantages of the present invention will be apparent from the following description.

In accordance with the present invention, there is provided a novel complex obtained by mixing an ampholytic and/or a semi-polar surfactant and a higher fatty acid.

In accordance with the present invention, there is also provided an emulsified composition contained in the above-mentioned novel complex.

#### BRIEF DESCRIPTION OF THE DRAWINGS

Fig. 1 is a graph showing the variation with time of the amount of a surfactant adsorbed to a higher fatty acid; and

Fig. 2 is an infrared adsorption spectrum diagram of the novel complex.

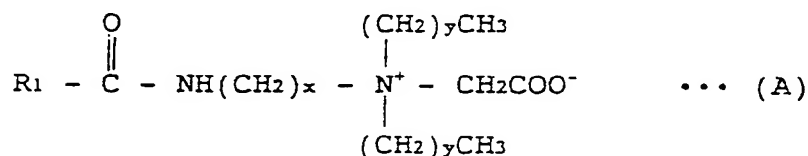
#### BEST MODE OF CARRYING OUT THE INVENTION

Specific and preferred embodiments of the present invention are now explained as follows.

#### AMPHOLYTIC SURFACTANT AND SEMI-POLAR SURFACTANT

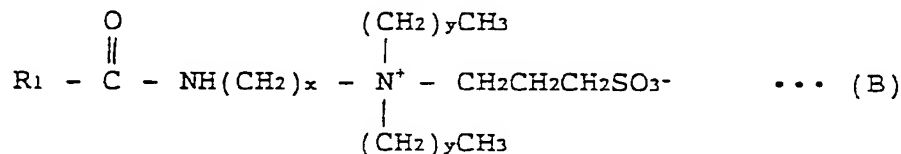
The examples of the ampholytic surfactants used in the present invention include any ampholytic surfactant used for ordinary cosmetic bases. Specific examples thereof are as follows.

(A) Amidobetaine ampholytic surface active agents represented by the general formula:



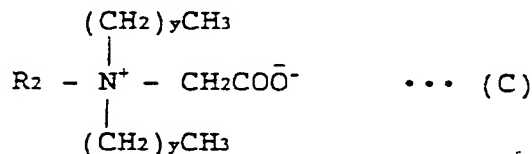
[Corresponding commercially available products are, e.g., "Lebon 2000" (produced by Sanyo Kasei K.K.) and "Anon BDF" (produced by Nihon Yushi K.K.)]

(B) Amidosulfobetaine ampholytic surfactants represented by the general formula:



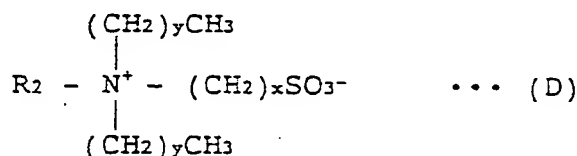
[Corresponding commercially available products are, "Ronzaine-CS" (produced by Ronza) and "Milataine CBS" (produced by Milano)]

(C) Betaine ampholytic surfactants represented by the general formula:



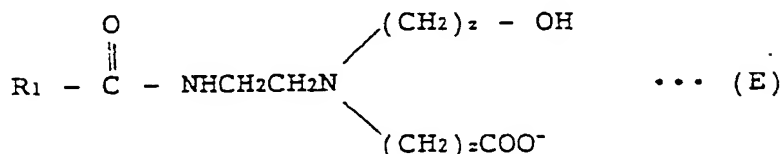
[Corresponding to, e.g., "Anon BL" (produced by Nihon Yushi K.K. and Dehainton AB-30 (produced by Henkel) as commercially available products]

(D) Sulfobetaine ampholytic surfactants represented by the general formula:



[For example, as a commercially available product, Ronzaine 12 CS (produced by Ronza) corresponds thereto]

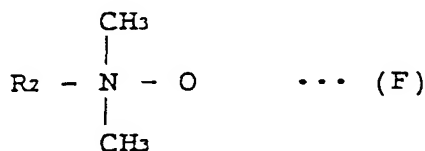
(E) Imidazolinium ampholytic surfactants represented by the general formula:



[As commercially available products, e.g., "Ovazoline 662-N" (produced by Toho Kagaku K.K.) and "Anon GLM" (Nihon Yushi K.K.) correspond thereto]

The semi-polar surfactant used in the present invention also includes any semi-polar surface active agent used for ordinary cosmetic bases, etc. Concrete examples thereof are as follows.

(F) Tertiary amine oxide semi-polar surfactants represented by the general formula:



[As commercially available products, e.g., "Unisafe A-LM" (produced by Nihon Yushi K.K.) and "Wondamine OX-100 (produced by Shin Nihon Rika K.K.) correspond thereto.]

In the foregoing general formulas (A) to (F),  $\text{R}_1$  denotes an alkyl or alkenyl group having 9 to 21 carbon atoms on average, an alkyl or alkenyl group having 11 to 17 carbon atoms on average being preferable, an alkyl or alkenyl group having 11 to 13 carbon atoms being most preferable. When the average number of carbon atoms in the group  $\text{R}_1$  is less than 9, the hydrophilic nature of the group is so strong that a complex is difficult to form, whereas when the average number more than 21, the solubility of the group in water becomes so bad that the group is also difficult to form.

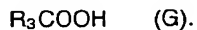
$\text{R}_2$  represents an alkyl or alkenyl group having 10 to 18 carbon atoms on average,  $x$  is an integer of 2 to 4,  $y$  an integer of 0 to 3, and  $z$  an integer of 1 or 2.

In the present invention, optionally, one or more of these ampholytic and semi-polar surfactants can be used.

#### HIGHER FATTY ACIDS

As the higher fatty acids used in the present invention, there are mentioned optional higher fatty acids used in ordinary cosmetic bases, etc., and concretely, the higher fatty acids represented by the following general formula (G) are mentioned.

General formula (G):



In the above formula,  $\text{R}_3$  denotes a saturated or unsaturated hydrocarbon radical having 7 to 25 carbon atoms on average with having a straight or branched chain or having a hydroxyl group, a saturated or unsaturated hydrocarbon having 9 to 23 carbon atoms on average with a straight or branched chain or having a hydroxyl group being preferable, and the most preferable being a saturated or unsaturated hydrocarbon having 11 to 21 carbon atoms on average with a straight or branched chain. When the average number of carbon atoms is less than 7, the hydrophilic nature of the higher fatty acid is so strong that a complex is difficult to form, whereas when the average number of carbon atoms is more than 25, the melting point of the higher fatty acid becomes so high that a complex becomes difficult to form.

Specific examples of such higher fatty acid are saturated fatty acids such as lauric acid, myristic acid, stearic acid, palmitic acid, arachic acid, behenic acid, etc.; unsaturated fatty acids such as 2-palmitoleic

acid, petrocelic acid, oleic acid, elaidic acid, recinoleic acid, linoleic acid, linoelaidic acid, linolenic acid, arachidonic acid etc.; branched fatty acids such as isostearic acid etc.; hydroxycarboxylic acids such as 12-hydroxystearic acid; etc. Among these higher fatty acids, saturated fatty acids having 18 carbon atoms are preferable from the viewpoint of stability and skin irritation, and among them, those having branches are especially preferable, more preferable being saturated fatty acids having 18 carbon atoms and having a methyl branch. As commercially available products of higher fatty acids, there may be mentioned, e.g., isostearic acid ("Emery #871, #875", produced by Emery Co., Ltd.) and so forth. In the present invention, optionally, one or more of these higher fatty acids may be used.

#### 10 CLAY MINERAL

As the clay minerals optionally used in the present invention, there are mentioned natural and synthetic water swelling clay minerals such as montmorillonite, zacanite, nontronite, saponite, hectorite, vermiculite, beagum, bentonite, silicate, fluorosilicate, magnesium, aluminium, synthetic hectorite (laponite) etc. Further, in the present invention, organic modified clay minerals obtained by treating these clay minerals with a quaternary ammonium type cationic surface active agent, e.g., Benton-27 (stearyldimethylbenzylammoniumhectorite chloride) and Benton-38 (distearyldimethylbenzylammoniumhectorite chloride) can be used.

The preferred amount of an added clay mineral is within the range of from 0.01 to 5% by weight, more centrifugal separation, the novel complex according to the present invention is suspended as a solid, so that the complex can be easily separated and recovered.

Further, the emulsion stability of the present invention is superior due to the presence of the clay mineral at the time of production. The clay mineral may be either first dispersed in an aqueous phase or dispersed in an oil phase according to the emulsification type. In the above example, by adding a higher fatty acid with a dispersed clay mineral to an aqueous solution of the ampholytic and/or semi-polar surfactant, a more stable novel complex is obtained.

#### USES OF NOVEL COMPLEX

The novel complex according to the present invention may be favorably used, e.g., as an emulsifier.

Namely, when an oily substance is present, this complex is orientated at the interface between water and oil, and functions as a strong interfacial film of the emulsion particle interface, and thus an emulsifier providing a strong emulsification capable of preventing a coalescence of the particles, which is not influenced by fluctuations in the required HLB of the oily substance, is obtained. Furthermore, since the HLB of the complex can be adjusted depending on the mixing ratio of the ampholytic and/or semi-polar surfactant and the higher fatty acid, the emulsification type can be easily selected.

#### PREPARATION OF EMULSIFIED COMPOSITION

The emulsified composition according to the present invention can be prepared by adding the above-mentioned novel complex according to the present invention to an oily substance-containing liquid, if necessary, under agitation and/or heating.

Although it takes 2 to 3 hours to make a stable emulsion system according to a normal method, it takes only one hour when the complex of the present invention is used, and the system can be completely emulsified by propeller agitation or the like, whereby the production process is simplified and shortened.

The emulsified composition also can be prepared according to the under-mentioned process, from the viewpoint of ease of preparation.

Namely, the emulsified composition can be prepared in such a way that a higher fatty acid is added to an oily substance, and the obtained mixture is agitated using, e.g., a disper, at room temperature, when the mixture is liquid at room temperature, and in a melted state under heating when it is solid at room temperature, and an aqueous solution of an ampholytic and/or semi-polar surfactant is added little by little to the mixture while the agitation is continued. When the fatty acid is difficult to dissolve in the oily substance, the emulsification efficiency can be increased by adding a solvent such as isoparaffin to the mixture.

With regard to additive components other than the emulsifier, these components can be added to the emulsified composition promptly after the preparation of the above emulsified composition, and then stirred slightly.

MIXING RATIO AND FORMULATING AMOUNT

In the present invention, a higher fatty acid and an ampholytic and/or semi-polar surfactant are blended in a blending ratio such that the weight ratio of the former to the latter is preferably within the range of from 0.5 : 9.5 to 9.5 : 0.5 {(higher fatty acid)/(ampholytic and/or semi-polar surfactant) = 0.05 to 19}, more preferably 1 : 9 to 9 : 1 {(higher fatty acid)/(ampholytic and/or semi-polar surfactant) = 0.1 to 9}. Such a mixing ratio can be properly set according to the objective emulsion type. When the mixing ratio is set within the range of from 0.5 : 9.5 to 9.5 : 0.5, the stability of the emulsified product is improved, and when set within the range of from 1 : 9 to 9 : 1, the stability thereof is further improved.

Further, the total amount of the surfactant and the higher fatty acid is preferably within the range of from 0.1 to 30% by weight, based on the total weight of the composition, more preferably from 0.5 to 20% by weight. When this amount is 0.1% by weight or more, the stability of the emulsified product is improved, and when it is 0.5% by weight or more, the stability thereof is further improved. Nevertheless, when a surfactant and higher fatty acid are contained in the whole composition in a proportion of 30% by weight or more, the effect is saturated, and therefore, the upper limit is preferably 30% by weight, from an economical point of view. Although the emulsification type varies depending upon the kind of oily substance, the proportion between water and oil, etc., the emulsification type is divided into two at roughly a weight ratio of 1 to 2 of the higher fatty acid and the ampholytic and/or semi-polar surfactant; O/W type below a ratio of 1 to 2, and W/O type above this ratio. Also by using a preparation method such as phase reversal emulsifying method, it becomes possible to prepare a stable multiphase emulsified product of, e.g., the W/O/W type or O/W/O type.

OPTIONAL CONTENTS

In the emulsified composition of the present invention, if necessary, other surfactants, viscosity regulators, medicative agents, humectants, preservatives, pH regulators, ultraviolet absorbers, etc., can be used in combination with the present novel complex.

As the other surfactant, there are mentioned, e.g., polyoxyethylene alkylether, polyoxyethylene fatty ester, polyoxyethylene sorbitan fatty ester, polyoxyethylene hardened castor oil, alkylsulfuric ester, polyoxyethylene alkylsulfuric ester, alkylphosphoric ester, polyoxyethylene alkylphosphoric ester, alkali metal salts of fatty acids, etc.

As the viscosity regulator, there are mentioned, e.g., high molecular compounds such as polyvinyl alcohol, carboxyvinyl polymer, carboxymethylcellulose, methylcellulose etc.; natural gums such as gelatin, traganth gum, etc.; and alcohols such as ethanol, isopropanol, etc.

As the medicative agent, there are mentioned, e.g., disinfectant, antiphlogistic agent, vitamins, etc.

As the humectant, there are mentioned, e.g., glycerine, propylene glycol, 1,3-butylene glycol, sorbitol, lactic acid, sodium lactate, sodium pyrrolidone carboxylate, etc.

As the preservative, there are mentioned, e.g., paraoxybenzoic ester, benzoic acid, sodium benzoate, sorbic acid, potassium sorbate, phenoxy ethanol, etc.

EMULSIFIED OILY SUBSTANCE

There is a wide variety, from polar oils to non-polar oils, of the oily substances which can be emulsified with the emulsifier of the present invention, and examples thereof include hydrocarbons such as liquid paraffin, branched chain light paraffin, paraffin wax, ceresin, squalene, etc.; waxes such as beeswax, spermaceti wax, carnauba wax, etc.; natural animal and plant fats and oils such as olive oil, camellia oil, hohova oil, lanolin, etc.; ester oils such as isopropyl myristate, cetyl isooctanoate, glyceryl trioctanoate, etc.; silicone oils such as decamethyl pentasiloxane, dimethyl polysiloxane, methyl phenyl polysiloxane, etc., and higher alcohols such as cetyl alcohol, stearyl alcohol, oleyl alcohol, etc. These may be used alone or as a mixture of two or more thereof. Further, among the above oily substances, a high viscosity silicone can be formed into a product with service properties similar to those of a W/O type emulsion, although the product is an O/W type.

USES OF EMULSIFIED COMPOSITION

The emulsified composition according to the present invention may be applied, as cosmetics, to skin care products such as cold cream, cleansing cream, etc.; hair care products such as hair cream, hair shampoo, hair mousse, hair rinse, etc.; makeup products such as foundation (face powder, powder), rouge,

eye makeup (mascara, etc.), etc.; body products, fingernail treatment cosmetics, etc. In addition, the present emulsified composition may be effectively used in a wide range of industrial fields such as releasing agents, water repellants, water-proofing agents, and pharmaceuticals and agricultural chemicals.

## 5 EXAMPLES

The present invention is now explained in detail with reference to Examples, which in no way limit the present invention.

### 10 Example 1

As an ampholytic surfactant, Ovazoline 662-N was used (10 mM), and as a higher fatty acid, oleic acid (17.73 mM) was used.

The latter was added to the former, and the mixture was agitated with a stirrer, and then the mixture  
15 was subjected to a centrifugal separation treatment. The amount of the Ovazoline 662-N remaining as sediment was measured using HPLC (High Performance Liquid Chromatography), to confirm whether the Ovazoline 662-N was adsorbed to oleic acid as time elapsed.

The results are shown in Fig. 1.

It can be seen from Fig. 1 that Ovazoline 662-N was reduced in amount as time elapsed, and adsorbed  
20 to oleic acid to form a complex.

Furthermore, the results of a measurement of the IR (Infrared Absorption Spectrum) for this system are shown in Fig. 2. It can be seen from Fig. 2 that the signal pattern of the complex was different from the superposition of the signal patterns of each component of the complex. Also, from the fact that the signal  
25 near a number of waves of  $940\text{ cm}^{-1}$  for -OH of oleic acid vanishes, after mixing both components, it can be seen that oleic acid is combined with Ovazoline 662-N in the carboxyl group portion of oleic acid.

From the foregoing results, it can be seen that the complex consisting of the ampholytic surface active agent and the fatty acid is a substance entirely different from these two components.

The melting point of this complex was determined and found to be  $100^{\circ}\text{C}$  or more.

### 30 Examples 2 to 11 and Comparative Examples 1 to 5

According to the foregoing procedures, the emulsified compositions with the compositions as set forth in Table 1 were prepared.

Aqueous solutions of anionic, ampholytic and nonionic surfactants dissolved in purified water were  
35 stirred in a homogenizer, and to the each solution thus obtained was added an oil in which a fatty acid was dissolved, whereby an emulsified product was prepared.

In Examples 4 and 5, the emulsification type was adjusted by phase inversion emulsifying method, i.e., the oil with a fatty acid dissolved therein was stirred in a homogenizer, and an aqueous solution of an ampholytic surfactant was added to the mixture thus homogenized, whereby an emulsified product was  
40 prepared.

The stability, emulsification type and skin irritation of the emulsified composition prepared as mentioned above were evaluated as follows.

### STABILITY OF EMULSIFIED COMPOSITION

45 After the emulsified composition had been allowed to stand for one month at room temperature, the size of the emulsified particles was compared with that of the particles immediately after the preparation of the emulsified composition, whereby the stability of the emulsified composition was evaluated according to the following criterion.

- 50 o No coalescence of particles recognized.
- Δ Slight coalescence of particles recognized.
- x Noticeable coalescence of particles recognized

and external view of emulsified composition showed that composition was divided into two layers.

### 55 Emulsification Type of the Emulsified Composition

The emulsification type of the emulsified composition was judged by the conductometric method and a microscopic inspection.



Skin Irritation

The skin irritation was evaluated by the protein denaturation rate measuring method, as explained in detail hereafter.

Utilizing water system high performance liquid chromatography, the concentration of the solution of the surfactant used in the emulsified composition was adjusted to 10 mM with an egg albumen buffering solution, having a pH of 7 and the egg albumen denaturation rate was measured using an absorption peak of 220 nm.

$$\text{Denaturation rate} = \frac{(\text{HO} - \text{HS}) \times 100}{\text{HO}}$$

HO: height of 220 nm absorption peak of egg albumen

HS: height of 220 nm absorption peak when a sample was added to egg albumen

o egg albumen denaturation rate below 30%

Δ egg albumen denaturation rate 30% or more, but less than 60%

x egg albumen denaturation rate of 60% or more

The above evaluation results are shown in Table 1.

As is clear from the results set forth in Table 1, each of the emulsified compositions according to the examples of the present invention had a low protein denaturation rate (i.e., low skin irritation) and an excellent stability, and can cope with a wide range of required HLB of an oily substance.

Various oily substances from liquid paraffin, a non-polar oil with low HLB to 2-octyl dodecanol, a polar oil with a relatively high HLB, further including silicone oil, which is considered to be difficult to emulsify, can be easily emulsified.

Especially, in Examples 2 to 9, the weight proportion of an ampholytic surfactant and a higher fatty acid was within the range of from 0.5 : 9.5 to 9.5 : 0.5, and the emulsified compositions had a greater stability than those of Examples 10 and 11.

Table 1

		Example								Comparative Example			Example	
		2	3	4	5	6	7	8	9	1	2	3	10	11
Oily substance	Liquid paraffin	48.5	47.75	46.25	31	-	-	47.75	47.75	48.5	48.5	48.5	30	50
	Methyl polysiloxane	-	-	-	-	-	30	-	-	-	-	-	-	-
	2-Octyl dodecanol	-	-	-	-	57.3	-	-	-	-	-	-	-	-
Emulsifier	Oleic acid	1.5	3	6	4	3	3	-	3	-	-	-	0.02	3
	Stearic acid	-	-	-	-	-	-	3	-	1.5	1.5	1.5	-	-
	Betaine lauryldimethyl aminoacetate	-	-	-	-	-	-	-	1.5	-	-	-	-	-
	Sodium 2-undecyl-N,N,N-(hydroxyethyl-Carboxymethyl)-2-imidazoline	1.5	1.5	1.5	0.6	1.5	1.5	1.5	-	-	-	-	3	0.02
	Sodium laurate	-	-	-	-	-	-	-	-	1.5	-	-	-	-
	Sodium laurylsulfate	-	-	-	-	-	-	-	-	-	1.5	-	-	-
	Polyoxyethylene hardened castor oil (EO-40)	-	-	-	-	-	-	-	-	-	-	1.5	-	-
Purified water	bal	bal	bal	bal	bal	bal	bal	bal	bal	bal	bal	bal	bal	
*1		1	2	4	6.67	2	2	2	2			0.007	150	
Stability		0	0	0	0	0	0	0	0	x	x	x	x	x
Emulsification Type		O/W	W/O	W/O/W	W/O/W	O/W	O/W	W/O	W/O	O/W	O/W	O/W	O/W	W/O
Protein Denaturation Rate (Skin Irritation)		0	0	0	0	0	0	0	0	x	x	x	0	0

\*1 (higher fatty acid)/(ampholytic and/or semi-polar surface active agent)(Wt.%)

## Example 12

Hair cream consisting of the following formulating ingredients in the following formulating ratios was prepared, and the properties of the thus produced preparation were evaluated in the same way as in

## Example 2.

The hair cream was prepared in the following manner.

To an aqueous layer formed by dissolving lauryldimethylamine oxide, glycerol and methyl parabane in purified water were added an oil phase mixture consisting of fluid paraffin, oleic acid, cetyl-2-ethyl  
 5 hexanoate, and an aromatic, while stirring in a homogenizer, whereby a hair cream was obtained.

O/W type hair cream	
Formulating ingredients	Wt.%
Lauryldimethylamine oxide	2.0
Oleic acid	2.0
Liquid paraffin	35.0
Cetyl-2-ethylhexanoate	3.0
Glycerol	5.0
Perfume	0.2
Methyl parabene	0.1
Purified water	balance

The hair cream thus prepared had an excellent stability and low skin irritation.

## Example 13

A cleansing cream consisting of the following formulating ingredients in the following formulating ratios  
 25 was prepared and evaluated in the same way as in Examples 2 to 11.

The cleansing cream was prepared by the following procedure.

To an aqueous phase formed by dissolving lauryldimethyl betaine aminoacetate, propylene glycol, methyl parabene, and butyl parabene in purified water was added an oil phase formed by melting stearic acid, fluid paraffin, cetanol, beeswax, spermaceti wax, lanolin, and perfume at a temperature of about 75 °C,  
 30 whereby a cleansing cream was obtained.

O/W type cleansing cream	
Formulating ingredients	Wt.%
Lauryldimethyl betaine aminoacetate	2.0
Stearic acid	2.0
Liquid paraffin	28.0
Cetanol	2.0
Beeswax	2.0
Spermaceti wax	5.0
Propylene glycol	3.0
Lanolin	1.0
Perfume	0.2
Methyl parabene	0.1
Butyl parabene	0.1
Purified water	balance

The cleansing cream thus prepared had an excellent stability and safety.

## Example 14

A cold cream consisting of the following formulating ingredients in the following formulating ratios was prepared, and evaluated in the same way as in Examples 2 to 10.

This cold cream was prepared by the following procedure.

An aqueous phase was added to an oil phase to obtain the cold cream.

W/O type cold cream	
Formulating ingredients	Wt. %
2-Undecyl-N,N,N-(hydroxyethylcarboxymethyl)-2-imidazoline sodium	2.0
Linoleic acid	6.0
Liquid paraffin	25.0
Lanolin alcohol	4.0
Beeswax	15.0
Paraffin wax	5.0
Borax	0.8
Perfume	0.4
Methyl parabene	0.1
Butyl parabene	0.1
Purified water	Balance

The cold cream thus prepared had an excellent stability and low skin irritation.

#### Example 15

A hair mousse consisting of the following formulating ingredients in the following formulating ratios was prepared. This hair mousse was prepared by the following procedure.

To an aqueous phase formed by dissolving 2-undecyl-N,N,N-(hydroxyethylcarboxymethyl)-2-imidazoline sodium to a part of purified water was added an oily substance mixture consisting of oleic acid, polydimethylsiloxane, and isoparaffin, while agitation was continued with a homogenizer, and an O/W type emulsified composition was obtained. Thereafter, the emulsified composition thus obtained was added to an aqueous solution consisting of propylene glycol, cationic high molecular compound, perfume, ethanol, and the remainder water, these elements were mixed, and then the obtained mixture was measured into a can, and n-butane was filled in the can.

O/W type hair mousse	
Formulating ingredients	Wt. %
2-Undecyl-N,N,N-(hydroxyethylcarboxymethyl)-2-imidazoline sodium	2.0
Oleic acid	2.0
Polydimethyl siloxane	2.0
Isoparaffin	8.0
Propylene glycol	3.0
Cationic polymer	0.1
Perfume	q.s.
Ethanol	10.0
Purified water	balance
n-Butane	10.0

The hair mousse according to the present example had an excellent stability and service properties, because the amount of surfactant required was about a half that of the conventional hair mousse, and the present hair mousse was not weighty. Also, the present hair mousse was more lustrous than the conventional mousse. The luster was evaluated by feeling. Furthermore, the present mousse had a low skin irritation.

#### Example 16

A hair mousse was prepared in the same way as in Example 15.

O/W type hair mousse	
Formulating ingredients	Wt. %
Betaine lauryldimethylaminoacetate	1.0
Oleic acid	0.1
Isoparaffin	0.1
Silicone oil	2.0
Glycerol	3.0
Ampholytic polymer	3.0
Perfume	q.s.
Ethanol	20.0
Purified water	balance
n-Butane	7.0

The hair mousse thus obtained had an excellent stability and low skin irritation.

#### Example 17

Hair spray consisting of the following formulating ingredients in the following formulating ratios was prepared.

This hair spray was prepared by the following procedure.

To an oil phase in which liquid paraffin and oleic acid were dissolved was added, while agitation was continued with a homogenizer, an aqueous phase in which sodium 2-undecyl-N,N,N-(hydroxyethylcarboxymethyl)-2-imidazoline were dissolved with a part of purified water, whereby a W/O type emulsified composition was obtained, and the composition thus obtained was filled in a can, and thereafter, a liquid mixture consisting of ethanol, perfume, anionic macromolecule and purified water was added to the composition, and a valve was mounted to the can, following which dimethyl ether was filled in the can, whereby the hair spray was obtained.

W/O type hair spray	
Formulating ingredients	Wt. %
2-Undecyl-N,N,N-(hydroxyethylcarboxymethyl)-2-imidazoline sodium	0.08
Oleic acid	0.3
Liquid paraffin	2.4
Ethanol	10.0
Perfume	q.s.
Anionic polymer	3.0
Dimethyl ether	75.0
Purified water	balance

The hair spray thus prepared had an excellent stability and low skin irritation.

#### Example 18

To a system in which a part of purified water, stearyltrimethylammonium chloride, and cetanol were dissolved under stirring at a temperature of about 75 °C, was added an O/W type emulsified composition obtained in the same way as in Example 12, whereby a hair rinse was obtained.

Hair rinse	
Formulating ingredients	Wt. %
2-Undecyl-N,N,N-(hydroxyethylcarboxymethyl)-2-imidazoline sodium	0.2
Oleic acid	0.2
Liquid paraffin	1.0
Cetyl-2-ethylhexanoate	1.0
Stearyltrimethylammonium chloride	1.5
Cetanol	1.5
Perfume	0.2
Metyl parabene	0.1
Purified water	remainder

The thus prepared hair rinse had an excellent stability and low skin irritation.

#### Example 19

A W/O type emulsified enamel consisting of the following formulating ingredients in the following formulating ratios was prepared by the procedures mentioned below, and evaluated in the same way as in Examples 2 to 11.

A liquid mixture of acetyltriethyl citrate, n-butyl acetate, toluene, and isostearic acid (Emery #871: produced by Emery Co., Ltd.) was prepared, and to the mixture thus prepared were added nitrocellulose RS 1-4, an acrylic resin, sucrose benzoate, and camphor, and these were dissolved under agitation. Subsequently, a pigment and an organic modified bentonite were added to the solution obtained and dispersed under agitation. Subsequently, ethylhydroxyethylcellulose dissolved in ethanol and purified water containing Ovazoline 662-N and propylene glycol were homogenously mixed, and the mixture obtained was added to the previously obtained dispersion, following which the newly obtained mixture was emulsified under agitation, whereby a red nail beautifying preparation was obtained.

W/O type emulsified enamel

	<u>Formulating ingredients</u>	<u>Wt. %</u>
5	<u>Ovazoline</u> 662-N (produced by Toho Kagaku K.K.) [effective content 30%]	1.7
	Isostearic acid ( <u>Emery</u> #871: produced by Emery Co., Ltd.)	2.0
10	Purified water	20.0
	Ethylhydroxyethylcellulose* <sup>1</sup>	0.5
	Propylene glycol	2.0
15	Nitrocellulose RS1/4* <sup>2</sup>	14.0
	Acrylic resin* <sup>3</sup>	6.0
	Sucrose benzoate	6.0
	Acetyltriethyl citrate	6.0
20	Camphor	1.5
	n-Butyl acetate	22.0
	Toluene	15.0
25	Pigment* <sup>4</sup>	1.0
	Organically modified bentonite* <sup>5</sup>	1.0
	Ethanol	5.0

\*1 Mixed cellulose ether, most of the three OH groups in cellulose being replaced by an ethoxyl or ethylhydroxyl group, the 5% viscosity in toluene/95%

ethanol (8 : 2) being 20 to 30 cps (25°C)

("EHEC-LOW": produced by Hercules Co., Ltd.)

\*2 Nitrocellulose with an isopropyl alcohol wetness of 30%; pyroxylin RS 1/4 (produced by Daisel Co., Ltd.)

\*3 70 : 30 copolymer of butyl acrylate and methyl methacrylate, the molecular weight thereof being about 200, ("Oligen BM-3" produced by Matsumoto Seiyaku Kogyo K.K.)

\*4 Deeve Maloon / titanium dioxide (4/1)

\*5 Distearyl chloride dimethylammonium hectorite

The W/O type emulsified enamel thus obtained had an excellent stability and low skin irritation.

Example 20

An O/W type creamy foundation consisting of the following ingredients in the following formulating ratios was prepared by the procedure as mentioned below, and evaluated in the same way as in Examples 2 to 11.

To an aqueous phase consisting of Ovazoline 662-N, purified water, dynamite glycerol and p-methyl benzoic acid was added a powder phase consisting of kaolin, talc, titanium dioxide, red iron oxide, yellow iron oxide, and black iron oxide, and emulsified under agitation was an oil phase consisting of propylene glycol, perfume, and isostearic acid ("Emery #871": produced by Emery Co. Ltd.), whereby an O/W type creamy foundation was obtained.

O/W type creamy foundation	
Formulating ingredients	Wt. %
Ovazoline 662-N (produced by Toho Kagaku K.K.) [effective content 30%]	7.5
Purified water	74.25
Dynamite glycerin	2.0
p-Methylbenzoic acid	0.1
Kaolin	5.0
Talc	10.0
Titanium dioxide	2.0
Red iron oxide	0.2
Yellow iron oxide	0.8
Black iron oxide	0.05
Propylene glycol	3.0
Perfume	0.1
Isostearic acid (Emery #871: produced by Emery Co., Ltd.)	0.25

The O/W type creamy foundation thus prepared had an excellent stability and low skin irritation.

Example 21

An O/W type creamy foundation consisting of the following ingredients in the following formulating ratios was prepared by the procedure as mentioned below, and evaluated in the same way as in Examples 2 to 11.

To an aqueous phase consisting of Ovazoline 662-N, purified water, dynamite glycerol, p-methyl benzoic acid and 1,3-butylene glycol was added a powder phase consisting of talc, titanium dioxide, red iron oxide, yellow iron oxide, and black iron oxide, and emulsified under agitation was an oil phase consisting of perfume, cyclic polysiloxane, and isostearic acid ("Emery #871": produced by Emery Co., Ltd.), whereby an O/W type creamy foundation was obtained.



O/W type creamy foundation		
	Formulating ingredients	Wt. %
5	Ovazoline 662-N (produced by Toho Kagaku K.K.) [effective content 30%]	13.5
	Purified water	65.35
	Dynamite glycerol	2.0
	p-Methyl benzoic acid	0.1
	1,3-Butylene glycol	3.0
10	Talc	13.65
	Titanium dioxide	5.0
	Red iron oxide	0.25
	Yellow iron oxide	1.0
	Black iron oxide	0.1
15	Perfume	0.05
	Cyclic polysiloxane	5.0
	Isostearic acid (Emery #871: produced by Emery Co., Ltd.)	0.45

The O/W type creamy foundation thus prepared had an excellent stability and low skin irritation.

#### Example 22

A W/O type creamy foundation consisting of the following ingredients in the following formulating ratios was prepared by the procedure as mentioned below, and evaluated in the same way as in Examples 2 to 11.

Into an oil phase consisting of a perfume, cyclic polysiloxane, and isostearic acid (Emery #871: produced by Emery Co., Ltd.) was emulsified under agitation an aqueous phase consisting of Ovazoline 662-N, purified water, dynamite glycerol, p-methyl benzoic acid, and 1,3-butylene glycol, and to the emulsion thus obtained was added a powder phase consisting of talc, titanium dioxide, red iron oxide, yellow iron oxide, and black iron oxide, whereby a W/O type creamy foundation was obtained.

W/O type creamy foundation		
	Formulating ingredients	Wt. %
35	Ovazoline 662-N (produced by Toho Kagaku K.K.) [effective content 30%]	1.5
	Purified water	65.35
	Dynamite glycerol	2.0
	p-Methylbenzoic acid	0.1
40	1,3-Butylene glycol	3.0
	Talc	13.65
	Titanium dioxide	5.0
	Red iron oxide	0.25
	Yellow iron oxide	1.0
45	Black iron oxide	0.1
	Perfume	0.06
	Cyclic polysiloxane	5.0
	Isostearic acid (Emery #871: produced by Emery Co., Ltd.)	4.05

The W/O type creamy foundation thus prepared had an excellent stability and low skin irritation.

#### Example 23

A high internal aqueous phase W/O type cream consisting of the following ingredients in the following formulating ratios was prepared by the procedure as mentioned below, and evaluated in the same way as in Examples 2 to 11.

Into an oil phase consisting of isoparaffin, dimethyl polysiloxane, liquid paraffin, cetyl octanoate, methyl phenyl polysiloxane, ethyl parabene, and isostearic acid (Emery #871: produced by Emery Co., Ltd.) was

emulsified under agitation an aqueous phase consisting of Ovazoline 662-N, dynamite glycerol, 1,3-butylene glycol, and purified water, whereby a high internal aqueous phase W/O type cream was obtained.

High internal aqueous phase W/O type creamy foundation	
Formulating ingredients	Wt. %
Ovazoline 662-N (produced by Toho Kagaku K.K.) [effective content 30%]	4.0
Dynamite glycerol	5.0
1,3-Butylene glycol	5.0
Isoparaffin	2.0
Dimethyl polysiloxane	1.0
Liquid paraffin	1.0
Cetyl isooctanoate	1.0
Methyl phenyl polysiloxane	1.0
Ethyl parabene	0.1
Purified water	balance
Isostearic acid (Emery #871: produced by Emery Co., Ltd.)	3.0

The high internal aqueous phase W/O type cream thus prepared had an excellent stability and low skin irritation.

#### Example 24

A W/O type hair cream consisting of the following ingredients in the following formulating ratios was prepared by the procedure as mentioned below, and evaluated in the same way as in Examples 2 to 11.

Into an oil phase consisting of isoparaffin, dimethyl polysiloxane 20cs, dimethyl polysiloxane (polymerization degree: 1000), vitamin E acetate, and isostearic acid (Emery #871: produced by Emery Co., Ltd.) was emulsified under agitation an aqueous phase consisting of Ovazoline 662-N, distearyldimethylammonium chloride, a perfume, purified water, polyethylene glycol 6000, methyl parabene, keratin hydrolyzate, lecithin, and smecton, whereby a W/O type hair cream was obtained.

W/O type hair cream

	<u>Formulating ingredients</u>	<u>Wt. %</u>
5	Isoparaffin	20.0
	Dimethyl polysiloxane 20cs	2.0
	Dimethyl polysiloxane (polymerization degree 1000)	5.0
10	Distearyldimethylammonium chloride	0.8
	Ovazoline 662-N (produced by Toho Kagaku K.K.) [effective content 30%]	1.6
	Vitamin E acetate	0.1
15	Isostearic acid (Emery #871: produced by Emery Co., Ltd.)	3.0
	Perfume	q.s.
	Purified water	balance
20	Polyethylene glycol 6000	1.0
	Glycerol	5.0
	Methyl parabene	0.2
25	Keratin hydrolyzate	0.05
	Smecton	1.2
	Lecithin	0.05

30 The W/O type hair cream thus prepared had an excellent stability and low skin irritation.

Example 25

35 An O/W type hair mousse consisting of the following ingredients in the following formulating ratios was prepared by the procedure as mentioned below, and evaluated in the same way as in Examples 2 to 11.

To an aqueous phase formed by dissolving Ovazoline 662-N, collagen hydrolyzate, and lecithin with a part of purified water was added under agitation an oil phase consisting of isostearic acid (Emery #871: produced by Emery Co., Ltd.), dimethyl polysiloxane (polymerization degree: 5000), and isoparaffin, whereby an O/W type hair mousse was obtained. The hair mousse thus obtained was added to an aqueous  
40 solution of purified water containing a perfume, ethanol, and methyl parabene, and mixed therein. The obtained mixture was measured into a can, and n-butane was filled into the can.

45

50

55

O/W type hair mousse

	<u>Formulating ingredients</u>	<u>Wt. %</u>
5	Ovazoline 662-N (produced by Toho Kagaku K.K.) [effective content 30%]	2.0
	Collagen hydrolyzate	0.05
10	Lecithin	0.05
	Isostearic acid (Emery #871: produced by Emery Co., Ltd.)	1.0
15	Dimethyl polysiloxane (polymerization degree 5000)	4.0
	Isoparaffin	12.0
20	Propylene glycol	5.0
25	Perfume	q.s.
	Ethanol	10.0
	Methyl parabene	0.2
30	Purified water	balance
	n-Butane	10.0

35 The hair mousse thus prepared had an excellent stability and low skin irritation. In addition, this hair mousse exhibited usabilities similar to those of a W/O type mousse, although the present mousse was an O/W type, and provided a gentle and soft hair dressing.

40 Example 26

A W/O type creamy mascara consisting of the following formulating ingredients in the following formulating ratios was prepared by the procedure as mentioned below, and evaluated in the same way as in Examples 2 to 11.

45 An oil phase portion consisting of isoparaffin, solid paraffin wax, beeswax, polyisoprene resin, isostearic acid (Emery #875: produced by Emery Co., Ltd.), and polyacrylic ester emulsion was heated to a temperature of 70°C, and stirred to be homogenized. An aqueous phase portion consisting of purified water, methyl parabene, perfume, organically modified bentonite, and Ovazoline 662-N was heated to a temperature of 70°C, and added to the oil phase portion, to be emulsified, whereafter the mixture thus  
50 emulsified was cooled and filled into a mascara vessel.

W/O type creamy mascara	
Formulating ingredients	Wt. %
Isoparaffin	30.0
Solid paraffin wax	3.0
Beeswax	3.0
Polyisoprene resin	3.0
Isostearic acid (Emery #875: produced by Emery Co., Ltd.)	2.5
Purified water	20.0
Polyacrylic ester emulsion	30.0
Methyl parabene	0.05
Perfume	q.s.
Organically modified bentonite (produced by National Lead Corporation)	2.0
Ovazoline 662-N (Toho Kagaku K.K.) [effective content 30%]	3.3

This W/O type creamy mascara thus prepared had an excellent stability and low skin irritation.

#### Example 27

An O/W type body rinse consisting of the following formulating ingredients in the following formulating ratios was prepared by the procedure as mentioned below, and evaluated in the same way as in Examples 2 to 11.

To an aqueous phase consisting of ethanol, 1,3-butylene glycol, Ovazoline 662-N, KOH, methyl parabene, xanthan gum, carboxyvinyl polymer, and purified water was added a powder phase consisting of mica-filled titanium, and an oil phase consisting of methyl polysiloxane, dimethyl polysiloxane - polyethylene glycol, isostearic acid (Emery #875: produced by Emery Co., Ltd.), and polyoxypropylene (9 mol) diglyceryl ether was emulsified into the obtained mixture under agitation, whereby an O/W type body rinse was obtained.

O/W type body rinse

	<u>Formulating ingredients</u>	<u>Wt. %</u>
5	Methyl polysiloxane	4.0
	Dimethyl polysiloxane polyethylene glycol (EO 24 mol)	4.0
10	Ethanol	1.0
	1,3-Butylene glycol	20.3
15	Ovazoline 662-N (produced by Toho Kagaku K.K.) [effective content 30%]	10.0
	Isostearic acid ("Emery #875": produced by Emery Co., Ltd.)	1.0
20	Polyoxypropylene (9 mol) diglyceryl ether	10.0
	Mica-filled titanium	0.2
25	KOH	0.25
	Methyl parabene	0.1
	Xanthan gum	0.5
30	Carboxyvinyl polymer	0.5
	Purified water	balance

35 The O/W type body rinse thus prepared had an excellent stability and low skin irritation.

Example 28

40 A W/O type emulsified enamel consisting of the following formulating ingredients in the following  
formulating ratios was prepared according to Example 11, and evaluated in the same way as in Examples 2  
to 11.

45

50

55

W/O type emulsified enamel

	<u>Formulating ingredients</u>	<u>Wt. %</u>
5	Lebon 2000 (produced by Sanyo Kasei K.K.) [effective content 30%]	1.7
	Linoleic acid	2.0
10	Purified water	20.0
	Ethylhydroxyethylcellulose* <sup>1</sup>	0.5
15	Propylene glycol	2.0
	Nitrocellulose RS 1/4* <sup>2</sup>	14.0
	Acrylic resin* <sup>3</sup>	6.0
20	Sucrose benzoate	8.0
	Acetyltriethyl citrate	6.0
25	Camphor	1.5
	n-Butyl acetate	22.0
	Toluene	15.0
30	Pigment* <sup>4</sup>	1.0
	Organically modified bentonite* <sup>5</sup>	1.0
35	Ethanol	5.0
*1	Cellulose ether mixture, many of the three OH groups in cellulose being replaced by an ethoxyl group or an ethylhydroxyl group, 5% viscosity thereof in toluene/95% ethanol (8 : 2) being 20 to 30 cps (EHEC-LOW: produced by Hercules Co., Ltd.)	
*2	Nitrocellulose with isopropyl alcohol wetness of which is 30%; pyroxylin RS 1/4 (produced by Daisel Co., Ltd.)	
*3	70 : 30 copolymer of butyl acrylate and methyl	

55

methacrylate, the molecular weight being about 2000,  
 ("Oligen" BM-3: Matsumoto Seiyaku Kogyo K.K.)

\*4 Dieve maloon / titanium dioxide (4/1)

\*5 Stearyldimethylbenzylammoniumhectrite chloride

The W/O type emulsified enamel thus prepared had an excellent stability and low skin irritation.

#### Example 29

An O/W type creamy foundation consisting of the following ingredients in the following formulating ratios was prepared by the procedure as described below, and evaluated in the same way as in Examples 2 to 11.

To an aqueous phase consisting of Ronzain-CS, purified water, dynamite glycerin, and p-methylbenzoic acid was added a powder phase consisting of kaolin, talc, titanium dioxide, red iron oxide, yellow iron oxide, and black iron oxide, and an oil phase consisting of propylene glycol, perfume, and linolenic acid was emulsified therein under agitation, whereby an O/W type creamy foundation was obtained.

O/W type creamy foundation	
Formulating ingredients	Wt. %
Ronzain-CS (produced by Ronza Co., Ltd.) [effective content 50%]	4.5
Purified water	74.25
Dynamite glycerol	2.0
p-Methylbenzoic acid	0.1
Kaolin	5.0
Talc	10.0
Titanium dioxide	2.0
Red iron oxide	0.2
Yellow iron oxide	0.8
Black iron oxide	0.05
Propylene glycol	3.0
Perfume	0.1
Linolenic acid	0.25

The O/W type creamy foundation thus prepared had an excellent stability and low skin irritation.

#### Example 30

An O/W type creamy foundation consisting of the following ingredients in the following formulating ratios was prepared by the procedure as mentioned below, and evaluated in the same way as in Examples 2 to 11.

To an aqueous phase consisting of Ronzain-CS, purified water, dynamite glycerin, p-methylbenzoic acid, and 1,3-butylene glycol was added a powder phase consisting of talc, titanium dioxide, red iron oxide, yellow iron oxide, and black iron oxide, and an oil phase consisting of perfume, cyclicpolysiloxane and lauric acid was emulsified therein under agitation, whereby an O/W type creamy foundation was obtained.



O/W type creamy foundation	
Formulating ingredients	Wt.%
Ronzain-CS (produced by Ronza Co., Ltd.) [effective content 50%]	8.0
Purified water	65.35
Dynamite glycerol	2.0
p-Methylbenzoic acid	0.1
1,3-Butylene glycol	3.0
Talc	13.65
Titanium dioxide	5.0
Red iron oxide	0.25
Yellow iron oxide	1.0
Black iron oxide	0.1
Perfume	0.05
Cyclic polysiloxane	5.0
Lauric acid	0.45

The O/W type creamy foundation thus prepared had an excellent stability and low skin irritation.

#### Example 31.

A W/O type creamy foundation consisting of the following ingredients in the following formulating ratios was prepared by the procedure as mentioned below, and evaluated in the same way as in Examples 2 to 11.

An aqueous phase consisting of Unisafe A-LM, purified water, dynamite glycerol, p-methylbenzoic acid, and 1,3-butylen glycol, which aqueous phase was formed by adding a powder phase consisting of talc, titanium dioxide, red iron oxide, yellow iron oxide, and black iron oxide, to an oil phase consisting of perfume, cyclic polysiloxane and stearic acid, and was emulsified under agitation, whereby an O/W type creamy foundation was obtained.

W/O type creamy foundation	
Formulating ingredients	Wt.%
Unisafe A-LM (produced by Nihon Yushi K.K.) [effective content 30%]	1.5
Purified water	65.3
Dynamite glycerol	2.0
p-Methylbenzoic acid	0.1
1,3-Butylene glycol	3.0
Talc	13.65
Titanium dioxide	5.0
Red iron oxide	0.25
Yellow iron oxide	1.0
Black iron oxide	0.1
Perfume	0.05
Cyclic polysiloxane	5.0
Stearic acid	4.05

The W/O type creamy foundation thus prepared had an excellent stability and low skin irritation.

#### Example 32

A high internal aqueous phase W/O type cream consisting of the following formulating ingredients in the following formulating ratios was prepared by the procedure as mentioned below, and evaluated in the same way as in Examples 2 to 11.

Into an oil phase consisting of isoparaffin, dimethyl polysiloxane, liquid paraffin, cetyl isooctanoate, methyl phenyl polysiloxane, ethyl parabene, and stearic acid was emulsified under agitation an aqueous

phase consisting of Anon BDF, dynamite glycerol, 1,3-butylene glycol, and purified water, whereby a high internal aqueous phase W/O type cream was obtained.

High internal aqueous phase W/O type cream	
Formulating ingredients	Wt. %
Anon BDF (produced by Nihon Yushi K.K.) [effective content 30%]	5.0
Dynamite glycerol	5.0
1,3-Butylene glycol	5.0
Isoparaffin	2.0
Dimethyl polysiloxane (6cps)	1.0
Liquid paraffin	1.0
Cetyl isooctanoate	1.0
Methyl phenyl polysiloxane (6cps)	1.0
Ethyl parabene	0.1
Purified water	balance
Stearic acid	3.0

The high internal aqueous phase W/O type cream thus prepared had an excellent stability and low skin irritation.

#### Example 33

A W/O type hair cream consisting of the following formulating ingredients in the following formulating ratios was prepared by the procedure as mentioned below, and evaluated in the same way as in Examples 2 to 11.

Into an oil phase consisting of isoparaffin, dimethyl polysiloxane (polymerization degree 1000), Miratine CBS, vitamin E acetate, and palmitic acid was emulsified under agitation an aqueous phase consisting of distearyldimethylammonium chloride, perfume, purified water, polyethylene glycol 6000, glycerol, methyl parabene, keratin hydrolyzate, and smecton, whereby a W/O type hair cream was obtained.

W/O type hair cream	
Formulating ingredients	Wt. %
Isoparaffin	20.0
Dimethyl polysiloxane 20cs	2.0
Dimethyl polysiloxane (polymerization degree 1000)	5.0
Distearyldimethylammonium chloride	0.8
Miratain CBS (produced by Miranol Co., Ltd.) [effective content 50%]	3.0
Vitamin E acetate	0.1
Palmitic acid	3.0
Perfume	q.s.
Purified water	balance
Polyethylene glycol 6000	1.0
Glycerol methyl parabene	5.0
Methyl parabene	0.2
Keratin hydrolyzate	0.1
Smecton	1.2

The W/O type hair cream thus prepared had an excellent stability and low skin irritation.

#### Example 34

An O/W type hair mousse consisting of the following formulating ingredients in the following formulating ratios was prepared by the procedure as described below, and evaluated in the same way as in Examples 2 to 11.

To an aqueous phase formed by dissolving Dehainton AB-30 in a part of purified water was added, while agitation was continued, an oil phase consisting of 12-hydroxystearic acid, dimethyl polysiloxane (polymerization degree: 5000), and isoparaffin, whereby an O/W type hair mousse was obtained. Subsequently, the hair mousse thus obtained was added to and mixed with an aqueous solution of purified water containing perfume, ethanol, and methyl parabene. The mixture obtained was measured into a can, and n-butane was filled into the can.

O/W type hair mousse	
Formulating ingredients	Wt.%
Dehainton AB-30 (produced by Henkel) [effective content 30%]	6.7
12-Hydroxystearic acid	1.0
Dimethyl polysiloxane (polymerization degree: 5000)	4.0
Isoparaffin	12.0
Propylene glycol	5.0
Perfume	q.s.
Ethanol	10.0
Methyl parabene	0.2
Purified water	balance
n-Butane	10.0

The O/W type hair mousse thus prepared had an excellent stability and low skin irritation. In addition, this hair mousse exhibited service properties similar to those of a W/O type hair mousse, although an O/W type, and provided gentle and soft hair dressing.

#### Example 35

A hair treatment was obtained in the same manner as in Example 14.

Hair treatment	
Formulating ingredients	Wt.%
Anon CBS (produced by Nihon Yushi K.K.) [effective content 30%]	4.0
Isostearic acid ("Emery #875": produced by Emery Co., Ltd.)	3.0
Stearyltrimethylammonium chloride	0.5
Isoparaffin	3.0
Squalan	0.5
2-Octyl dodecanol	0.5
Dimethyl polysiloxane (polymerization degree: 5000)	0.2
Cetanol	0.5
Organically modified bentonite*	0.3
Perfume	0.2
Methyl parabene	0.1
Glycerol	2.0
1,3-Butylene glycol	1.0
Purified water	balance

\* stearyldimethylbenzylammoniumhectolite chloride

The hair treatment thus prepared made the hair glossy, and had a hair setting ability, although a W/O type, and had an excellent stability and low skin irritation.

#### Example 36

A W/O type creamy mascara consisting of the following formulating ingredients in the following formulating ratios was prepared by the procedure as mentioned below, and evaluated in the same way as in Examples 2 to 11.

An oil phase portion consisting of isoparaffin, solid paraffin wax, beeswax, polyisoprene resin, isostearic acid ("Emery #875": produced by Emery Co., Ltd.), and polyacrylic ester emulsion was heated to a temperature of 70 °C, and agitated to be homogenized. An aqueous phase portion consisting of purified water, methyl parabene, perfume, organic modified bentonite, and Anon GLM was heated to a temperature of 70 °C, and added to the oil phase portion to be emulsified, and thereafter, the emulsified product obtained was cooled and filled in a mascara vessel.

W/O type creamy mascara	
Formulating ingredients	Wt. %
Isoparaffin	30.0
Solid paraffin wax	3.0
Beeswax	3.0
Polyisoprene resin	3.0
Isostearic acid ("Emery #875": Produced by Emery Co., Ltd.)	3.0
Purified water	20.0
Polyacrylic ester emulsion	30.0
Methyl parabene	0.05
Perfume	q.s.
Organically modified bentonite (produced by National Lead Corporation)	2.0
Anon GLM (produced by Nihon Yushi K.K.) [effective content 30%]	3.3

The W/O type creamy mascara thus prepared had an excellent stability and low skin irritation.

#### Example 37

An O/W type body rinse consisting of the following formulating ingredients in the following formulating ratios was prepared by the procedure as described below, and evaluated in the same way as in Examples 2 to 11.

To an aqueous phase consisting of ethanol, 1,3-butylene glycol, Ovazoline 662-N, KOH, methyl parabene, xanthan gum, carboxyvinyl polymer, and purified water was added a powder phase consisting of mica-filled titanium, and further, emulsified under agitation was an oil phase consisting of methyl polysiloxane, dimethyl polysiloxane - polyethylene glycol, isostearic acid ("Emery #875": produced by Emery Co., Ltd.), and polyoxypropylene (9 mol) diglyceryl ether, whereby an O/W type body rinse was obtained.

#### O/W type body rinse

<u>Formulating ingredients</u>	<u>Wt. %</u>
Methyl polysiloxane	4.0
Dimethyl polysiloxane polyethylene glycol (EO 24 mols)	4.0
Ethanol	1.0
1,3-Butylene glycol	20.0
Wandamin OX-100 (produced by Shin Nihon Rika K.K.) [effective content 35%]	8.6

	Isostearic acid ("Emery #875": produced by Emery Co., Ltd.)	1.0
5	Polyoxypropylene (9 mol) diglyceryl ether	10.0
	Mica-filled titanium	0.2
	KOH	0.25
10	Methyl parabene	0.1
	Xanthan gum	0.5
15	Carboxyvinyl polymer	0.5
	Purified water	balance

The O/W type body rinse thus prepared had an excellent stability and low skin irritation.

#### Examples 38 and 39

Emulsified compositions consisting of the formulating ingredients set forth in Table 2, respectively, in the formulating ratios also set forth in Table 2, were prepared, and the influences of clay minerals upon an emulsified system examined. The results are set forth in Table 2.

Table 2

	Example 38	Example 39
Ovazoline 662-N (produced by Toho Kagaku K.K.)	5.0	5.0
Isostearic acid "Emery #875" (produced by Emery Co., Ltd.)	3.0	3.0
Dynamite glycerol	5.0	5.0
1,3-Butylene glycol	5.0	5.0
Decamethylcyclopentasiloxane	4.0	4.0
Ethyl parabene	0.1	0.1
* Organically modified bentonite	-	0.3
Purified water	83.9	83.6
Stability	Storable for one month at room temperature	Storable for 6 months at room temperature and for a further 2 months at 50°C

\* Distearyltrimethylammoniumhectorite chloride

As shown in the table, it has been found that the emulsified composition of Example 39, which is formed by adding distearyltrimethylammoniumhectorite chloride to the emulsified composition of Example 38, has an excellent long term stability, and even under more severe conditions (50°C), the emulsification system consisting of the emulsified composition of Example 39 is noticeably stable.

#### APPLICABILITY IN INDUSTRY

As explained in detail in the foregoing, according to the present invention there is provided a novel complex displaying an excellent emulsification of even an oily substance with a wide range of required HLB, capable of easily controlling the emulsion type, and of forming a stable and low skin irritation emulsified composition.

According to the present invention, there can be also provided an emulsified composition, which can be easily produced even if an oily substance with a wide range of required HLB, having an excellent stability, and displaying a low irritation of the skin.

Therefore, the emulsified composition according to the present invention may be used effectively as an emulsifier in a wide range of industrial fields, such as cosmetics, medicines, agricultural chemicals, releasing agents, water repellants, emulsion fuels, and emulsion polymerization, etc.

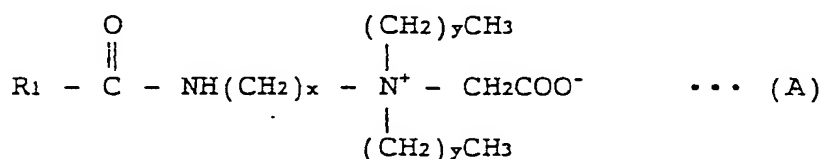
## 5 Claims

1. A novel complex obtained by mixing at least one surfactant selected from the group consisting of ampholytic and semi-polar surfactants, and a higher fatty acid.

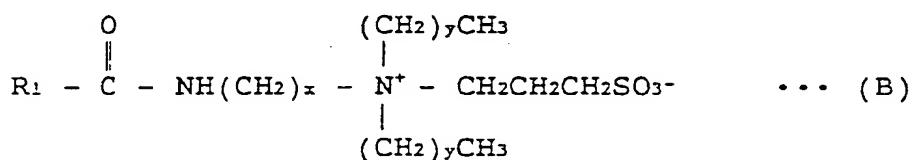
2. A novel complex as claimed in Claim 1, further comprising 0.01 to 5% by weight of a clay mineral.

3. A novel complex as claimed in Claim 1 or 2, in which at least one surfactant selected from the group consisting of ampholytic and semi-polar surfactants are represented by the following general formulae:

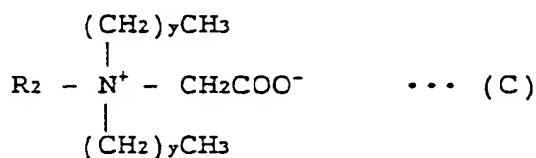
(A) amidobetaine ampholytic surfactant represented by the general formula



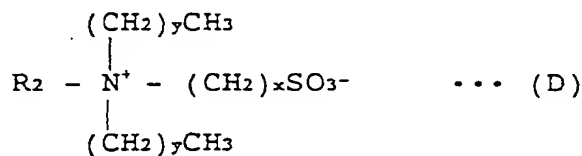
(B) amidosulfobetaine ampholytic surfactant represented by the general formula:



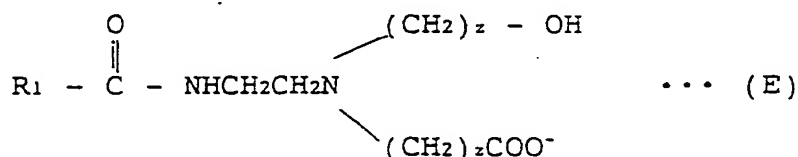
(C) betaine ampholytic surfactant represented by the general formula:



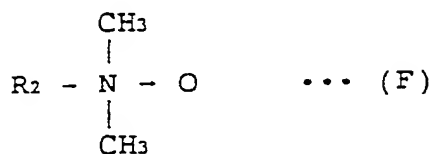
(D) sulfobetaine ampholytic surfactant represented by the general formula:



(E) imidazolinium ampholytic surfactant represented by the general formula:

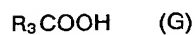


(F) tertiary amine oxide semi-polar surfactant represented by the general formula:



(in the above general formulae (A) to (F),  $\text{R}_1$  represents an alkyl or alkenyl group having 9 to 17 carbon atoms on average,  $\text{R}_2$  an alkyl or alkenyl group having 10 to 18 carbon atoms on average,  $x$  is an integer of 2 to 4,  $y$  an integer of 0 to 3, and  $z$  1 or 2)

4. A novel complex as claimed in any one of Claims 1 to 3, in which the higher fatty acid is represented by the following general formula (G)



wherein  $\text{R}_3$  is a saturated or unsaturated hydrocarbon having 7 to 25 carbon atoms on average with a straight or branched chain or having a hydroxyl group.

5. An emulsified composition characterized by containing a complex set forth in any one of Claims 1 to 4.
6. An emulsified composition as claimed in Claim 5, in which the weight ratio between at least one surfactant selected from said ampholytic and semi-polar surfactants and said higher fatty acid is within the range of from 0.5 : 9.5 to 9.5 : 0.5.



Fig. 1

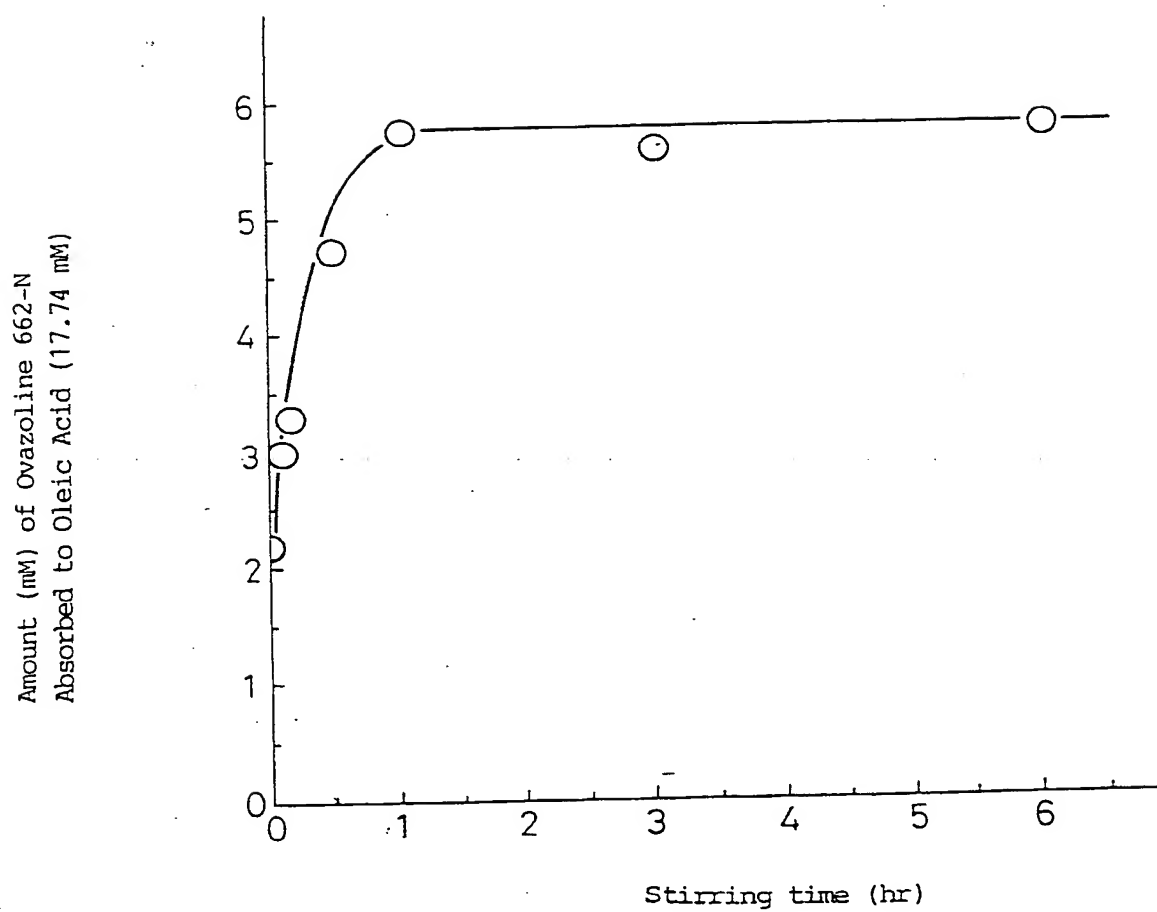
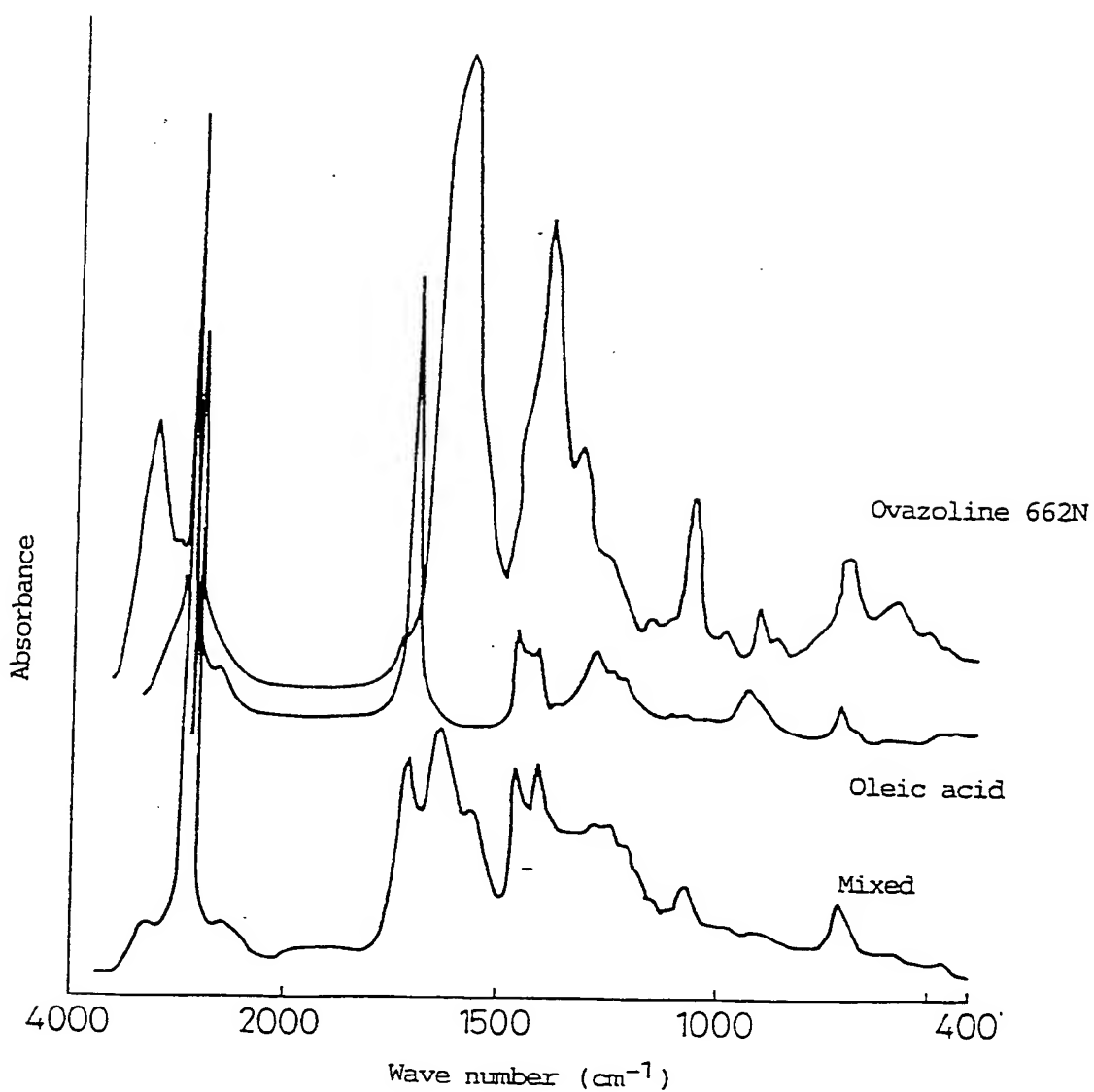


Fig. 2



# INTERNATIONAL SEARCH REPORT

International Application No PCT/JP91/00807

<b>I. CLASSIFICATION OF SUBJECT MATTER</b> (if several classification symbols apply, indicate all) <sup>4</sup>		
According to International Patent Classification (IPC) or to both National Classification and IPC		
Int. Cl <sup>5</sup> B01F17/00, 17/16, 17/22, 17/26, 17/28, B01J13/00, A61K7/00, 7/06		
<b>II. FIELDS SEARCHED</b>		
Minimum Documentation Searched <sup>7</sup>		
Classification System	Classification Symbols	
IPC	B01F17/00-17/56, B01J13/00, A61K7/00-7/50, C11D1/88-1/92	
Documentation Searched other than Minimum Documentation to the Extent that such Documents are Included in the Fields Searched <sup>8</sup>		
<b>III. DOCUMENTS CONSIDERED TO BE RELEVANT <sup>9</sup></b>		
Category <sup>6</sup>	Citation of Document, <sup>11</sup> with indication, where appropriate, of the relevant passages <sup>12</sup>	Relevant to Claim No. <sup>13</sup>
X	JP, A, 63-308097 (Kanebo, Ltd.), December 15, 1988 (15. 12. 88), (Family: none)	1, 3-5
X	JP, A, 61-271029 (Kanebo, Ltd.), December 1, 1986 (01. 12. 86), (Family: none)	1, 3-5
X	JP, A, 60-222142 (Shiseido Co., Ltd.), November 6, 1985 (06. 11. 85), (Family: none)	1, 3-5
X	JP, A, 60-197614 (Shionogi & Co., Ltd.), October 7, 1985 (07. 10. 85) & EP, A2, 155737 & EP, A3, 155737	1, 3-5
X	JP, A, 62-185798 (Noevier Co., Ltd.), August 14, 1987 (14. 08. 87), (Family: none)	1, 3-5
X	JP, A, 60-49099 (Wilkinson Sword Ltd.), March 18, 1985 (18. 03. 85) & AU, A1, 3091184 & FR, A1, 2549848	1, 3-5
<p><sup>10</sup> Special categories of cited documents:</p> <p>"A" document defining the general state of the art which is not considered to be of particular relevance</p> <p>"E" earlier document but published on or after the international filing date</p> <p>"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)</p> <p>"O" document referring to an oral disclosure, use, exhibition or other means</p> <p>"P" document published prior to the international filing date but later than the priority date claimed</p> <p>"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention</p> <p>"X" document of particular relevance: the claimed invention cannot be considered novel or cannot be considered to involve an inventive step</p> <p>"Y" document of particular relevance: the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art</p> <p>"Z" document member of the same patent family</p>		
<b>IV. CERTIFICATION</b>		
Date of the Actual Completion of the International Search	Date of Mailing of this International Search Report	
August 30, 1991 (30. 08. 91)	September 17, 1991 (17. 09. 91)	
International Searching Authority	Signature of Authorized Officer	
Japanese Patent Office		

Form PCT/ISA/210 (second sheet) (January 1985)

## FURTHER INFORMATION CONTINUED FROM THE SECOND SHEET

	& DE, A1, 3426058 & GB, A1, 2143841 & ZA, A, 8405168 & BR, A, 8403553 & GB, A0, 8320154 & FI, A0, 842939 & GB, A0, 8416978 & BE, A1, 900216 & FI, A, 842939	
X	JP, A, 2-59511 (Shiseido Co., Ltd.), February 28, 1990 (28. 02. 90)	1, 3-5
X	JP, A, 59-196723 (Lion Corp.), November 8, 1984 (08. 11. 84), (Family: none)	1, 3-5
X	JP, A, 55-129141 (Rowarl Keshohin K.K.),	1, 3-5

V. ☐ OBSERVATIONS WHERE CERTAIN CLAIMS WERE FOUND UNSEARCHABLE <sup>1</sup>

This international search report has not been established in respect of certain claims under Article 17(2) (a) for the following reasons:

1. ☐ Claim numbers , because they relate to subject matter not required to be searched by this Authority, namely:

2. ☐ Claim numbers , because they relate to parts of the international application that do not comply with the prescribed requirements to such an extent that no meaningful international search can be carried out, specifically:

3. ☐ Claim numbers , because they are dependent claims and are not drafted in accordance with the second and third sentences of PCT Rule 6.4(a).

VI. ☐ OBSERVATIONS WHERE UNITY OF INVENTION IS LACKING <sup>2</sup>

This International Searching Authority found multiple inventions in this international application as follows:

1. ☐ As all required additional search fees were timely paid by the applicant, this international search report covers all searchable claims of the international application.

2. ☐ As only some of the required additional search fees were timely paid by the applicant, this international search report covers only those claims of the international application for which fees were paid, specifically claims:

3. ☐ No required additional search fees were timely paid by the applicant. Consequently, this international search report is restricted to the invention first mentioned in the claims; it is covered by claim numbers:

4. ☐ As all searchable claims could be searched without effort justifying an additional fee, the International Searching Authority did not invite payment of any additional fee.

Remark on Protest

☐ The additional search fees were accompanied by applicant's protest.

☐ No protest accompanied the payment of additional search fees.

## FURTHER INFORMATION CONTINUED FROM THE SECOND SHEET

	October 6, 1980 (06. 10. 80) & JP, B2, 60-4729	
X	JP, A, 53-103987 (L'Oreal), September 9, 1978 (09. 09. 78) & BE, A1, 864148 & DE, A1, 2807607 & NL, A, 7801983 & ES, A1, 467222 & ES, A5, 467222 & FR, B1, 2381558 & GB, A, 1570563 & CA, A1, 1110970 & CH, A, 628804 & US, A, 4337241	1, 3-5
X	JP, A, 49-48843 (Nippon Chemical K.K.), May 11, 1974 (11. 05. 74) & JP, B2, 53-6215	1, 3-5

V. ☐ OBSERVATIONS WHERE CERTAIN CLAIMS WERE FOUND UNSEARCHABLE <sup>1</sup>

This international search report has not been established in respect of certain claims under Article 17(2) (a) for the following reasons:

1. ☐ Claim numbers . because they relate to subject matter not required to be searched by this Authority, namely:
2. ☐ Claim numbers . because they relate to parts of the international application that do not comply with the prescribed requirements to such an extent that no meaningful international search can be carried out, specifically:
3. ☐ Claim numbers . because they are dependent claims and are not drafted in accordance with the second and third sentences of PCT Rule 6.4(a).

VI. ☐ OBSERVATIONS WHERE UNITY OF INVENTION IS LACKING <sup>2</sup>

This International Searching Authority found multiple inventions in this international application as follows:

1. ☐ As all required additional search fees were timely paid by the applicant, this international search report covers all searchable claims of the international application.
2. ☐ As only some of the required additional search fees were timely paid by the applicant, this international search report covers only those claims of the international application for which fees were paid, specifically claims:
3. ☐ No required additional search fees were timely paid by the applicant. Consequently, this international search report is restricted to the invention first mentioned in the claims; it is covered by claim numbers:
4. ☐ As all searchable claims could be searched without effort justifying an additional fee, the International Searching Authority did not invite payment of any additional fee.

## Remark on Protest

- ☐ The additional search fees were accompanied by applicant's protest.
- ☐ No protest accompanied the payment of additional search fees.

FURTHER INFORMATION CONTINUED FROM THE SECOND SHEET

Y	JP, A, 2-49713 (Shiseido Co., Ltd.), February 20, 1990 (20. 02. 90)	2
A	JP, B2, 58-38480 (The Proctor and Gamble Co.), August 23, 1983 (23. 08. 83) & DE, A1, 2432053 & FR, A1, 2236929 & JP, A, 50-70411 & AU, A1, 7081874 & GB, A, 1437857 & US, A, 4005027 & IT, A, 1017032 & CA, A1, 1032431 & IE, B, 39871 & FR, B1, 2236929 & DE, C2, 2432053	2
A	JP, B2, 54-6593 (Nippon Unigel K.K.),	2

☒ OBSERVATIONS WHERE CERTAIN CLAIMS WERE FOUND UNSEARCHABLE

This international search report has not been established in respect of certain claims under Article 17(2) (a) for the following reasons:

1. ☐ Claim numbers , because they relate to subject matter not required to be searched by this Authority, namely:
2. ☐ Claim numbers , because they relate to parts of the international application that do not comply with the prescribed requirements to such an extent that no meaningful international search can be carried out, specifically:
3. ☐ Claim numbers , because they are dependent claims and are not drafted in accordance with the second and third sentences of PCT Rule 6.4(a).

VI. ☐ OBSERVATIONS WHERE UNITY OF INVENTION IS LACKING <sup>2</sup>

This International Searching Authority found multiple inventions in this international application as follows:

1. ☐ As all required additional search fees were timely paid by the applicant, this international search report covers all searchable claims of the international application.
2. ☐ As only some of the required additional search fees were timely paid by the applicant, this international search report covers only those claims of the international application for which fees were paid, specifically claims:
3. ☐ No required additional search fees were timely paid by the applicant. Consequently, this international search report is restricted to the invention first mentioned in the claims; it is covered by claim numbers:
4. ☐ As all searchable claims could be searched without effort justifying an additional fee, the International Searching Authority did not invite payment of any additional fee.

### Remark on Protest

- ☐ The additional search fees were accompanied by applicant's protest.  
☐ No protest accompanied the payment of additional search fees.

## FURTHER INFORMATION CONTINUED FROM THE SECOND SHEET

A	March 29, 1979 (29. 03. 79), (Family: none)  Kokichi Hikime and others "Handbook-Cosmetics Preparation Material - revised edition" February 1, 1977 (01. 02. 77), Nikko Chemicals, Tokyo p.336-345	1-6
---	--	-----

V. ☐ OBSERVATIONS WHERE CERTAIN CLAIMS WERE FOUND UNSEARCHABLE <sup>1</sup>

This international search report has not been established in respect of certain claims under Article 17(2) (a) for the following reasons:

1. ☐ Claim numbers , because they relate to subject matter not required to be searched by this Authority, namely:
  
2. ☐ Claim numbers , because they relate to parts of the international application that do not comply with the prescribed requirements to such an extent that no meaningful international search can be carried out, specifically:
  
3. ☐ Claim numbers , because they are dependent claims and are not drafted in accordance with the second and third sentences of PCT Rule 6.4(a).

VI. ☐ OBSERVATIONS WHERE UNITY OF INVENTION IS LACKING <sup>2</sup>

This International Searching Authority found multiple inventions in this international application as follows:

1. ☐ As all required additional search fees were timely paid by the applicant, this international search report covers all searchable claims of the international application.
2. ☐ As only some of the required additional search fees were timely paid by the applicant, this international search report covers only those claims of the international application for which fees were paid, specifically claims:
3. ☐ No required additional search fees were timely paid by the applicant. Consequently, this international search report is restricted to the invention first mentioned in the claims; it is covered by claim numbers:
4. ☐ As all searchable claims could be searched without effort justifying an additional fee, the International Searching Authority did not invite payment of any additional fee.

## Remark on Protest

- ☐ The additional search fees were accompanied by applicant's protest.  
☐ No protest accompanied the payment of additional search fees.

THIS PAGE BLANK (CSPTO)